



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D4895-047
Job Sheet 181265



Part No: D4895-047

Job Qty: 2 ea

Part Name: Aft Outboard Beam Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/24/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IIP REV:A 14.07.25 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	2 Ea	8/31/18	8/31/18	0.00	0.00	Start Up Waterjet		DL 18/07/28
100	Waterjet	2 pcs	8/31/18	8/31/18	0.00	1.57	Waterjet1		DL 18/07/28
110	CNC Vertical Machining	2 pcs	8/31/18	8/31/18	0.62	5.88	HAAS1-5		DJP 18/07/30
120	QC	2 pcs	8/31/18	8/31/18	0.00	0.00	QC2 Machining-3		DJP 18/07/30
150	QC	2 pcs	8/31/18	8/31/18	0.00	0.00	QC8 Machining-3		DJP 18-07-30
160	HandFinish	2 pcs	8/31/18	8/31/18	0.00	0.38	HandFinish1		SA 18-07-30
170	QC	2 pcs	8/31/18	8/31/18	0.00	0.00	QC7-4		DL 18-7-30
171	Powdercoat	2 pcs	8/31/18	8/31/18	0.00	0.21	Powdercoat1		DL 18-08-01
172	QC	2 pcs	8/31/18	8/31/18	0.00	0.00	QC3		DAS
180	Small Fab	2 pcs	8/31/18	8/31/18	0.00	0.47	Small Fab-8		9 DAS
190	QC	2 pcs	8/31/18	8/31/18	0.00	0.00	QC5		AUG 29 2018 68
200	Packaging	2 pcs	8/31/18	8/31/18	0.00	0.00	Packaging3-2		AUG 31 2018 9-89
210	QC21-SA	2 Ea	8/31/18	8/31/18	0.00	0.00	QC21		21 AUG 31 2018 9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X12.000	6061-T6 Bar 1.00 X 12.00	6.0200 ft (3.01 ea)	90-Start up Operation	5033408/138540
D4859-1	Bushing	8 Ea (4 ea)	180-Small Fab	5097596

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X12.000	6	24	0
180-Small Fab	D4859-1	8	0	0

Part Specifications

Specifications could not be found.

Plex 7/27/18 11:52 AM dart.lacelle.lir

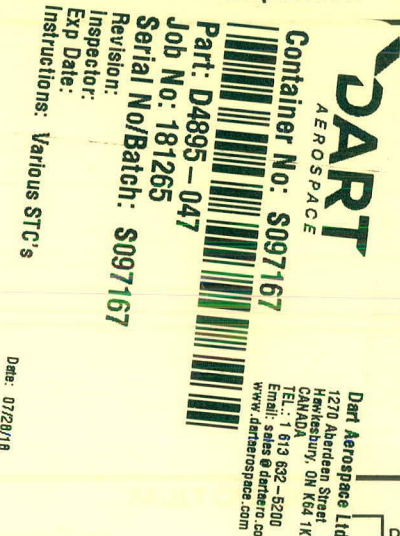
DQA:

WORK ORDER NON-CONFORMANCE / UPDATE

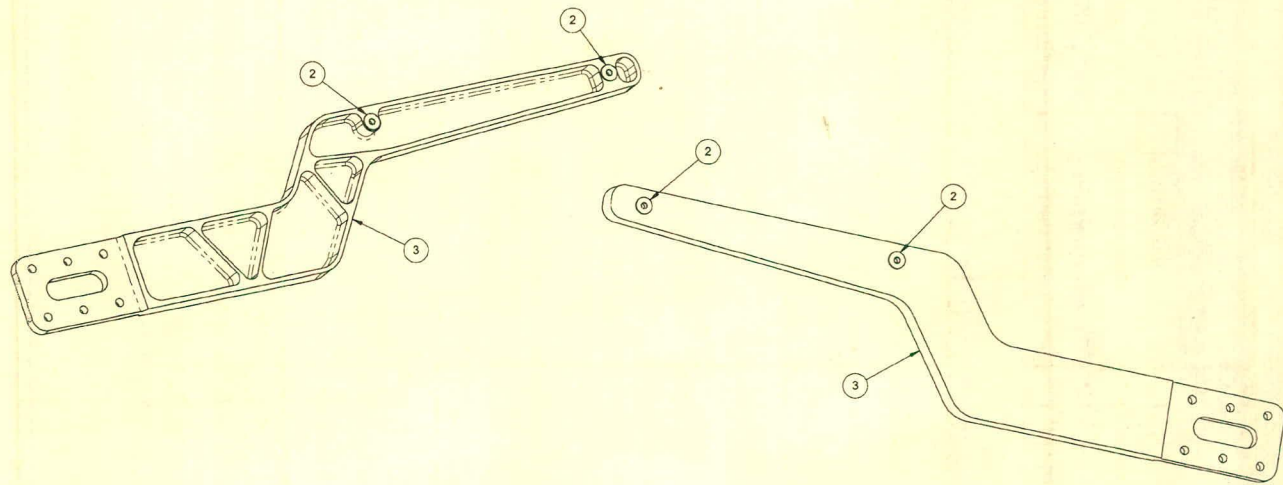
QA Closed: _____ Date: _____

Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval															
Disposition Part: D4895 - 047 Job No: 181265 Serial No/Batch: S097167 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 07/20/18 						Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval															
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐															
OTHER : _____																					

ITEM	QTY -047	P/N	DESCRIPTION
1	X	D4895-047	AFT OUTBOARD BEAM ASSY
2	4	D4859-1	BUSHING
3	1	D4895-7	AFT OUTBOARD BEAM



D4895-047 AFT OUTBOARD BEAM ASSY

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 3.44 lbs
 - 8) PRESS FIT D4859-1 INTO D4895-7. IT IS ACCEPTABLE USE MAGNABOND ADHESIVE, REMOVE EXCESS ADHESIVE FROM BUSHING HOLE

APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	VS	DRAWING NO.	REV. B
	MFG. APPR.	JLM	D4895	SHEET 4 OF 9
	APPROVED	HS	TITLE	SCALE
DE APPR.	DE	OUTBOARD BEAM	NTS	
DATE	14.04.11	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIALITY IS NOT APPLIED TO THE EXTENT OF THE INFORMATION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIES OR COMMUNICATIONS TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

RELEASED
2014-07-24
MT

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

DART AEROSPACE LTD		Work Order:	
Description: Aft Outboard Beam		Part Number:	D4895-7
Inspection Dwg: D4895	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
CNC Milling	32.55	+/-0.030	32.550				
	R1.50	+/-0.030	1.500				
	R0.38	+/-0.030	0.380				
	4.63	+/-0.030	4.630				
	5.75	+/-0.030	5.750				
	0.250	+/-0.010	0.250				
	0.150	+/-0.010	0.159				
	3.00	+/-0.030	3.00				
	R0.43	+/-0.030	0.430				
	0.200	+/-0.010	0.200				
	0.750	+/-0.010	0.750				
	Ø0.425	+0.000/-0.002	0.424				
	6.97	+/-0.030	6.971				
	0.93	+/-0.030	0.926				
	0.85	+/-0.030	0.849				
	1.00	+/-0.030	1.012				
	R0.13	+/-0.030	0.125				
	0.150	+/-0.010	0.150				
	Ø0.377	+0.006/-0.001	0.380				
	3.00	+/-0.030	3.000				
	1.15	+/-0.030	1.148				
	Ø1.00	+/-0.030	1.000				
	2.300	+/-0.005	2.300				
	0.60	+/-0.030	0.598				
	0.80	+/-0.030	0.798				
	3.600	+/-0.005	3.600				
	1.800	+/-0.005	1.800				
	1.75	+/-0.030	1.7495				
	3.50	+/-0.030	3.499				
Manual Mill	0.25	+/-0.030	0.252				
	5.50	+/-0.030	5.50				
	12.000	+/-0.005	12.000				
	1.55	+/-0.030	1.550				
	Ø0.465 X 90°	+/-0.010 x 0.5°	0.468 x 90°				
	R0.25	+/-0.030	0.250				
	0.500	+/-0.010	0.503				

DAS

Measured by: DSP	Audited by: 20 9-89	Preliminary Approval:
Date: 18/07/30	Date: 18-07-30	Date:

Rev	Date	Change	Revised by	Approved
A	14.08.05	New Issue	KJ	

247
10
318